

Work Order ID 63030

Monday, October 18, 2010 12:50:22 PM



PRELIMINARY ISSUE

Page 1

Item ID: D429-793-011

Accept



Setup Start



Revision ID: PRELIM

Item Name: Bearpaw Installation

Stop



Start Date: 10/18/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/20/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *MB*

Date: *10-10-18*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN-D429-793	PA1

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D429-793-011 CHG 1

N/A

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

(X)

Dh.
10/10/18.

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

for flight test.
10/10/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging	Packaging	0.00				10/14/10	5		
Packaging	Memo Identify and pack for shipping as per PPP D429-793-011 Location: _____	0.00							
140  QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

~~Kit was flight tested + returned to DAS ENG.~~
KIT WAS FLIGHT
TESTED + RETURNED
TO DAS ENG.

10.11.12.

MF
10-10-18
RD1301 NOV.

Picklist Print

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Page 1

Work Order ID: 63030

Parent Item: D429-793-011

Parent Item Name: Bearpaw Installation






Start Date: 10/18/2010

Required Date: 10/20/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: Rev. A New Issue 10/10/18 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status																																																																						
AN4C12A ✓  BOLT		Purchased	No			110	Each	287.0000	8	8																																																																									
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D3980-041 ✓  Bearpaw Assembly		Manufactured	No	B63011		110	Each	0.0000	2	2																																																																									
D4176-1 ✓  429 Clamp, Top		Manufactured	No	B62203		110	Each	0.0000	6	6																																																																									

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 63030

Parent Item: D429-793-011

Parent Item Name: Bearpaw Installation

Start Date: 10/18/2010

Required Date: 10/20/2010

Start Qty: 1.00

Required Qty: 1.00

D4176-3 ✓
429 Clamp, Bottom

Manufactured No B 62704 110 Each 0.0000

2 2 - Oh.

D4211-041 ✓
Wearplate

Manufactured No B 62942 - x1 110 Each 0.0000

2 2 - Oh.

D4212-1 ✓
429 Clamp Cushion

Manufactured No B 62699 - x4 110 Each 0.0000

6 6 - Oh.

M321043-4 ✓
Nut

Purchased No 110 Each 667.0000

12 12

Location

Loc Qty

Loc Code

FG 40
104603 40
ST301 627
112492 25
113069 8
114523 294
114784 300

12 - Oh.

NAS1149D0463J ✓
Washer

Purchased No 110 Each 1,265.000

24 24

Location

Loc Qty

Loc Code

ST298 1265
10096 10
114576 68
115622 446
115647 741

24 Oh.

W/O:		WORK ORDER CHANGES					
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3.0 INSTALLATION PROCEDURE

- 3.1 Jack up the aircraft. If installed, remove any existing bearpaw installation. Skid wearplates and/or wear pads may be removed in the area of the bearpaw. Seal holes using Sikaflex- 241/-291 or Proseal 890 or MIL-S-8802 Class 2B sealant. Ensure skid is serviceable and free from wear and/or damage.
- 3.2 If installing the bearpaw over the wearplates/wear pads, the bearpaw may be relieved to clear wearplates/wear pads mounting screws provided the relief leaves 0.125" (3.18 mm) minimum thickness.
- 3.3 Refer to Figure 2. Position the bearpaw on the aft end of each skidtube so that the bearpaw clamps are located on either side of the aft saddle as applicable.
- 3.4 Install the D3980-041 Bearpaw on the skidtube using the D4176-1/-3 Clamps, D4212-1 Clamp Cushion, D4211-041 Wearplate and associated hardware as shown in Figure 2.
CAUTION: The torque on the nuts should be limited to 20 in-lb.
- 3.5 Although not generally necessary, it is acceptable to use longer or shorter AN4 bolts to ensure 1.5-4 threads in safety on the nuts. Additional NAS1149D0463J washers may also be installed under the nuts.
- 3.6 Lower the aircraft

4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D429-793-011	21.0 lb	0.0 in	0.0 lb-in	275.8 in	5792 in-lb
Bearpaw Installation	9.5 kg	0.0 m	0.0 m-kg	7.0 m	66.5 m-kg

5.0 PARTS LIST

QTY -011	Part Number	Description
X	D429-793-011	BEARPAW INSTALLATION
12	D2274 ✓	RADIUS BLOCK
2	D3980-041 ✓	BEARPAW
6	D4176-1 ✓	CLAMP, TOP
2	D4176-3 ✓	CLAMP, BOTTOM
2	D4211-041 ✓	WEARPLATE
6	D4212-1 ✓	CLAMP CUSHION
8	AN4C12A ✓	BOLT
4	AN4C15A ✓	BOLT
12	MS21043-4 ✓	NUT
24	NAS1149D0463J ✓	WASHERS

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Revision: **A**
Date: 10.10.04